

Date: Tuesday, 16/12/2008 3:06:23 PM  
User: Linda Lacelle

**Process Sheet**

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BRACKET
<b>Job Number</b> : 44135	
<b>Estimate Number</b> : 11181	
<b>P.O. Number</b> :	<b>Part Number</b> : D32941
<b>This Issue</b> : 16/12/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3294 REVB
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 43650	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 23/12/2008 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM Est Rev:C 08-07-16 Redesign part DD verified by:EC Est Rev:D 08-10-06 revB as per dwg DD verified by:EC	

**Additional Product**

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S080	2024-T3 .080 sheet
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**Comment:** Qty.: 2.1072 sf(s)/Unit Total : 4.2145 sf(s)  
Material: 2024-T3 (QQ-A-250/4) 0.080" thick  
(M2024T3S.080)  
Identify for D3294-1  
Batch: 109424

109424

18 8-12-17

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
1-Cut as per Dwg D3294  
Dwg Rev: B  
Prog Rev: B  
\*\*\*\*grain direction on a 45 deg as per dwg\*\*\*\*  
2-Deburr if necessary

18 8-12-17

2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

18 8-12-17

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5681217 42

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 44135

Part Number: D32941

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1- deburr

2- Form as per Dwg D3294

Ensure angle is correct

5 08/12/17 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/12/17 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FX 08/12/17

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11-20  
320 OF  
11-50

M-1 08/12/18

(2X)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

FX 08/12/18 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P/N using white fine point permanent ink marker, then Stock

Location: 211

8/12/18

2X

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



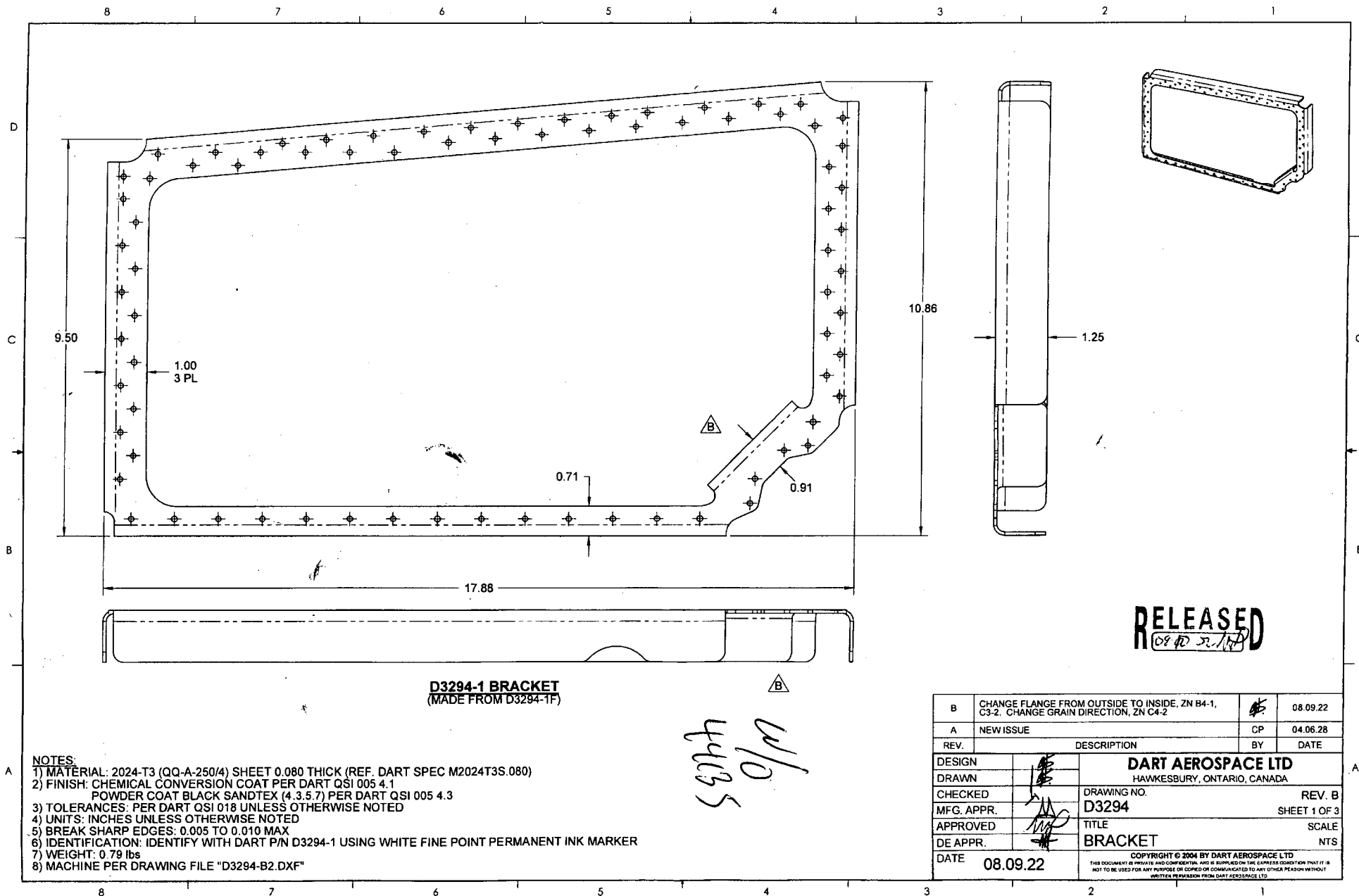
Comment: FINAL INSPECTION/W/O RELEASE

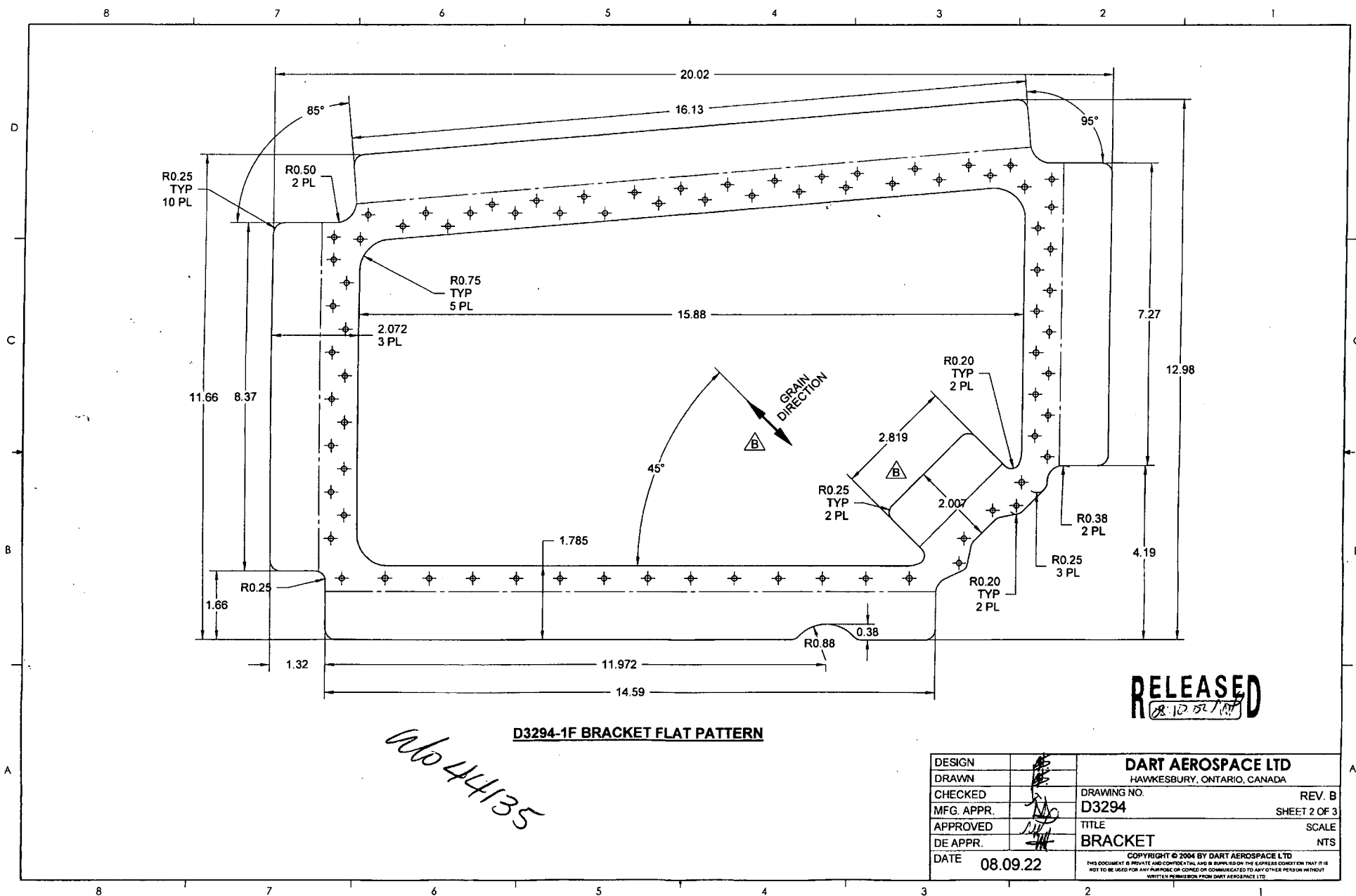
08/12/22

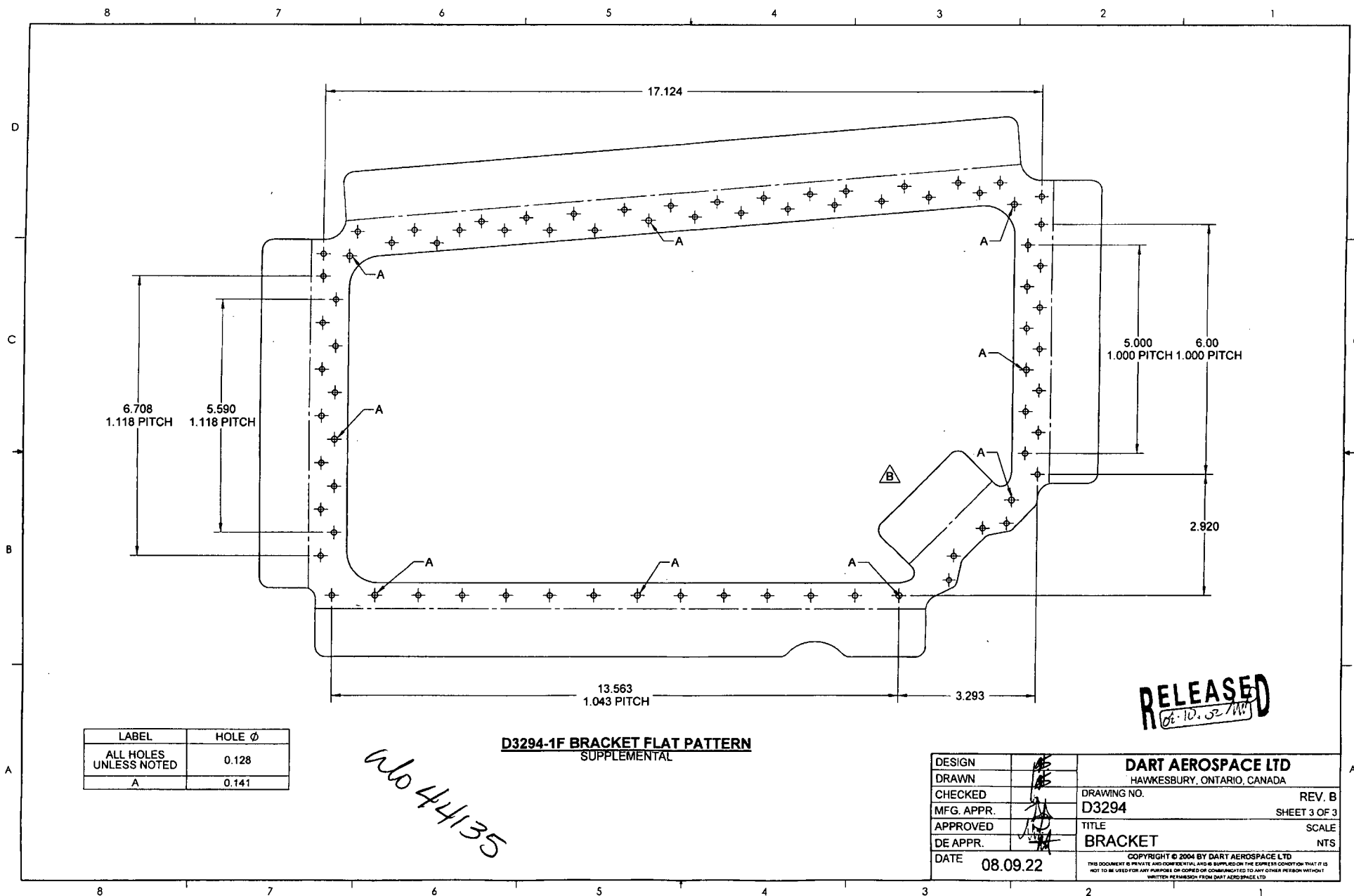
Job Completion



MF 08-12-19







<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 44135
<b>Description:</b> BRACKET		<b>Part Number:</b> D 3294-1
<b>Inspection Dwg:</b> D3294-1, Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 128	+ .005 - .001	131	X			
Ø 141	+ .005 - .001	142	X			
20.02	+/- .030	20.02	X			
16.13	+/- .030	16.13	X			
8.37	+/- .030	8.375	X			
11.66	+/- .030	11.69	X			
1.66	+/- .030	1.661	X			
1.32	+/- .030	1.315	X			
11.972	+/- .010	11.972	X			
14.59	+/- .030	14.59	X			
2.072	+/- .010	2.072	X			
1.785	+/- .010	1.792	X			
138	+/- .030	1381	X			
4.19	+/- .030	4.200	X			
7.27	+/- .030	7.274	X			
12.98	+/- .030	12.99	X			
15.88	+/- .030	15.875	X			
2.819	+/- .010	2.826	X			
2.007	+/- .010	2.009	X			
1.000	+/- .010	1.000	X			
1.118	+/- .010	1.117	X			
17.124	+/- .010	17.124	X			
13.523	+/- .010	13.563	X			
1.043	+/- .010	1.044	X			

<b>Measured by:</b> IB
<b>Date:</b> 8-12-17

<b>Audited by:</b> S
<b>Date:</b> 08/12/17

<b>Prototype Approval:</b> n
<b>Date:</b> 14

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	